








Work Order ID 58595


Wednesday, May 12, 2010 8:46:54 AM


Page 1

Item ID: D4016-3	Accept		Setup	Start	
Revision ID:					
Item Name: Hinge Half, Lid				Stop	
Start Date: 5/12/2010	Start Qty: 6.00		Cust Item ID:		
Required Date: 5/14/2010	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>mf</u>	Date: <u>10-5-12</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4016	A								

100	Cut blanks as per folio	0.00						
								
Bandsaw	Memo	0.00	<u>mf 10/05/14</u>			<u>6</u>	<u>0</u>	
Jeaspa Bandsaw	CUT BLANK as per folio							

110		0.00						
								
HAAS I	Memo	0.00	<u>SP 10/05/15</u>			<u>6</u>	<u>0</u>	
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA874 AND DWG FOLIO REV: <u>AA</u> DWG REV: <u>A</u>							
	DEBURR							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4016-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half, Lid

Start Date: 5/12/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

SL 10/05/15

QC

Memo

0.00

6

6

Quality Control

130



QC8- Inspect parts - second check

0.00

SL 10/05/16

QC

Memo

0.00

6

Quality Control

160

Identify as per dwg & Stock Location boxed

0.00

Packaging

Memo

0.00

⑥ PD 10.05.18

Packaging

W/O:		WORK ORDER CHANGES					
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Setup Start



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Start Date: 5/12/2010 Start Qty: 6.00



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Required Date: 5/14/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/18 *[Signature]*B/10-5-18
(6)

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Picklist Print

Wednesday, May 12, 2010 8:46:53 AM

Page 1

Work Order ID: 58595



Parent Item: D4016-3



Parent Item Name: Hinge Half, Lid

Start Date: 5/12/2010

Required Date: 5/14/2010

Comments: I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	17.9789	0.08			
304 bar 1.00 x 1.00												

Location

Loc Qty

Loc Code

MAT54

17.97894368

113290

17.9789437

.503 *mk 10/05/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

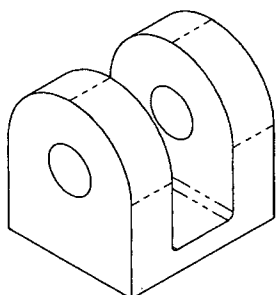
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

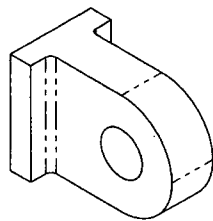
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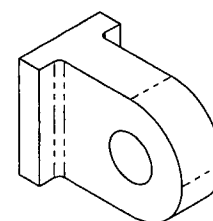
#58595



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

RELEASED
2010-02-16
mp

A		NEW ISSUE		JPH	10.01.29
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED	<i>[Signature]</i>	DRAWING NO.		REV. A	
MFG. APPR.	<i>[Signature]</i>	D4016		SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE		SCALE	
DE APPR.	<i>[Signature]</i>	BASKET HINGE		NTS	
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

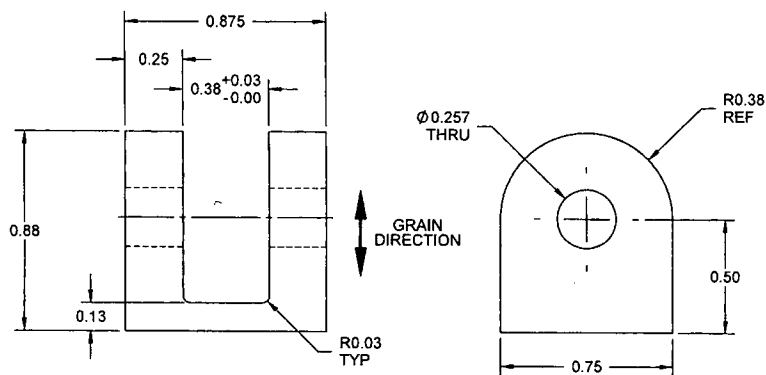
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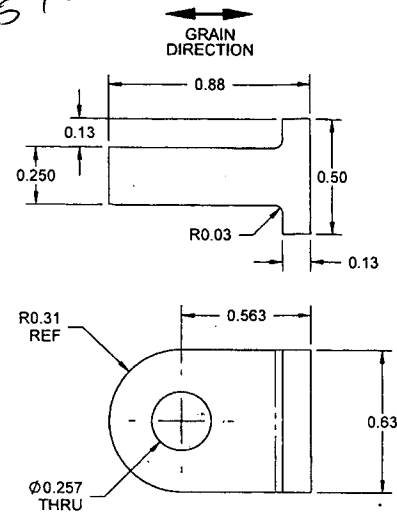
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX





6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4016	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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